
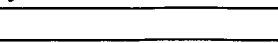


Date: Friday, 6/16/2006 1:36:55 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 27566
 Estimate Number : 11174
 P.O. Number : N/A
 This Issue : 6/16/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : 6/15/2006 Type : PURCHASED PARTS
 Previous Run : 26932
 Written By : 
 Checked & Approved By : 
 Comment : Est. B 05.05.25 Added Step 11 KJ/JLM
 Est. C 06.05.09 Ecn 798 EC

Drawing Name : REPLACEMENT WINDOW ASSEMBLY

Part Number : D3290041
 Drawing Number : D3290 REV B
 Project Number : N/A
 Drawing Revision : B
 Material : N/A
 Due Date : 7/5/2006

Qty: 8 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

M/ 06 07 15

2.0 M5052H32S040 5052-H32 .040 Sheet



Comment: Qty.: 3.7500 sf(s)/Unit Total : 30.0000 sf(s)
 5052-H32 .040 Sheet

M/ 06 07 15 20

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:08:02 20

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

J 06-08-23 Counted 18

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SAD 06:09:02 17

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

G.m 06-08-12 18

Date: Friday, 5/16/2006 1:36:55 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT WINDOW ASSEMBLY

Job Number: 27566

Part Number: D3290041

Job Number:



Seq. #: Machine Or Operation: Description :

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

A.M. 06-09-12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 09 12

9.0

D2126

Seal



Comment: Qty.: 6.5000 f(s)/Unit Total: 52.0000 f(s)

Locking Seal

Pick:

Qty Part Number Description Batch

1 D2126-0780 Locking Seal

B27842

10.0

D32901

Window Frame



Comment: Qty.: 0.0000 Each(s)/Unit Total: 0.0000 Each(s)

Window Frame

Pick:

Qty Part Number Description Batch

1 D3290-1 Window Frame

B27566

→ 970

→ 970

11.0

D32903

Window



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Window

Pick:

Qty Part Number Description Batch

1 D3290-3 Window

B27090

44.95

SAD

06:09:13

12

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3290

Clean D3290-041 and place in plastic wrap

SAD

06:09:13

13

Date: Friday, 3/16/2006 1:36:55 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT WINDOW ASSEMBLY

Job Number: 27566

Part Number: D3290041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 04/09/14

(13)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

1/A

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

(13)

04/09/18

Job Completion



Stock 5 Window Frame
3290-1 B 27566
✓
u

u dec 9-15

→

Date: Thursday, 6/15/2006 1:42:07 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: REPLACEMENT WINDOW ASSEMBLY
Job Number	: 27566		
Estimate Number	: 11174		
P.O. Number	:	Part Number	: D3290041
This Issue	: 6/15/2006 S.O. No. :	Drawing Number	: D3290 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: 26932	Material	:
Written By	: <u>HA 060615</u>	Due Date	: 7/5/2006
Checked & Approved By	: <u>HA 060615</u>	Qty:	<u>20</u> Um: Each
Comment	: Est. B 05.05.25 Added Step 11 KJ/JLM Est. C 06.05.09 Ecn 798 EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O:

Manufacture D3290-1 as per Dwg D3290

Possible Supplier: GFI

Material release note is required

Material 5052H32 .040" THK
 (MS052H32S.040)

(3.75 SF) M101875 (2)

Batch: M15982
 H17835 (12)

0704

2.0 D32904F Window Frame



Water Jet B
 Dry Rev B



Comment: Qty.: 1.0000 U(s)/Unit Total: 8.0000 U(s)

Replacement Window Assy

SAD

06:08:21

20

3.0 PACKAGING T PACKAGING RESOURCE #1

RC2



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0 QCB DIMENSIONAL CHECK

QCB



Comment: DIMENSIONAL CHECK

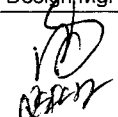

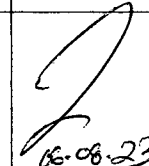
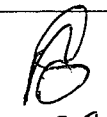

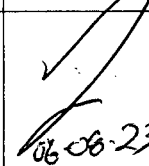
5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-08-23	2	2 parts scrap. Deep scratches in the mat'l.	 	Des from no replace.	SAD 06-08-23	 06-08-23	 	 06-08-23

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/09/18

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/15/2006 1:42:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT WINDOW ASSEMBLY

Job Number: 27566

Part Number: D3290041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

D2126

Seal



Comment: Qty.: 6.5000 f(s)/Unit Total : 52.0000 f(s)

Locking Seal

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2126-0780	Locking Seal	
---	------------	--------------	--

10.0

D32901

Window Frame



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Window Frame

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D3290-1	Window Frame	
---	---------	--------------	--

11.0

D32903

Window



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Window

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D3290-3	Window	
---	---------	--------	--

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/15/2006 1:42:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT WINDOW ASSEMBLY

Job Number: 27566

Part Number: D3290041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3290

Clean D3290-041 and place in plastic wrap

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

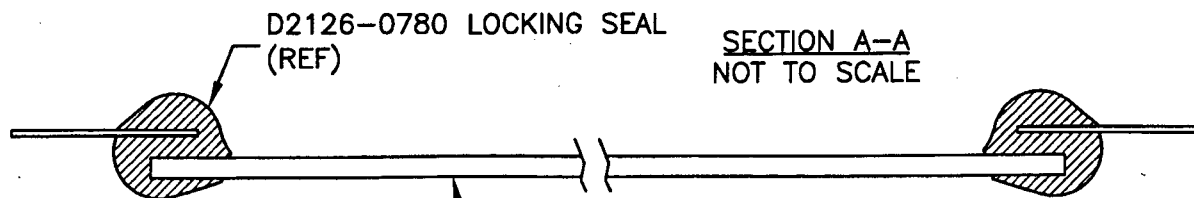
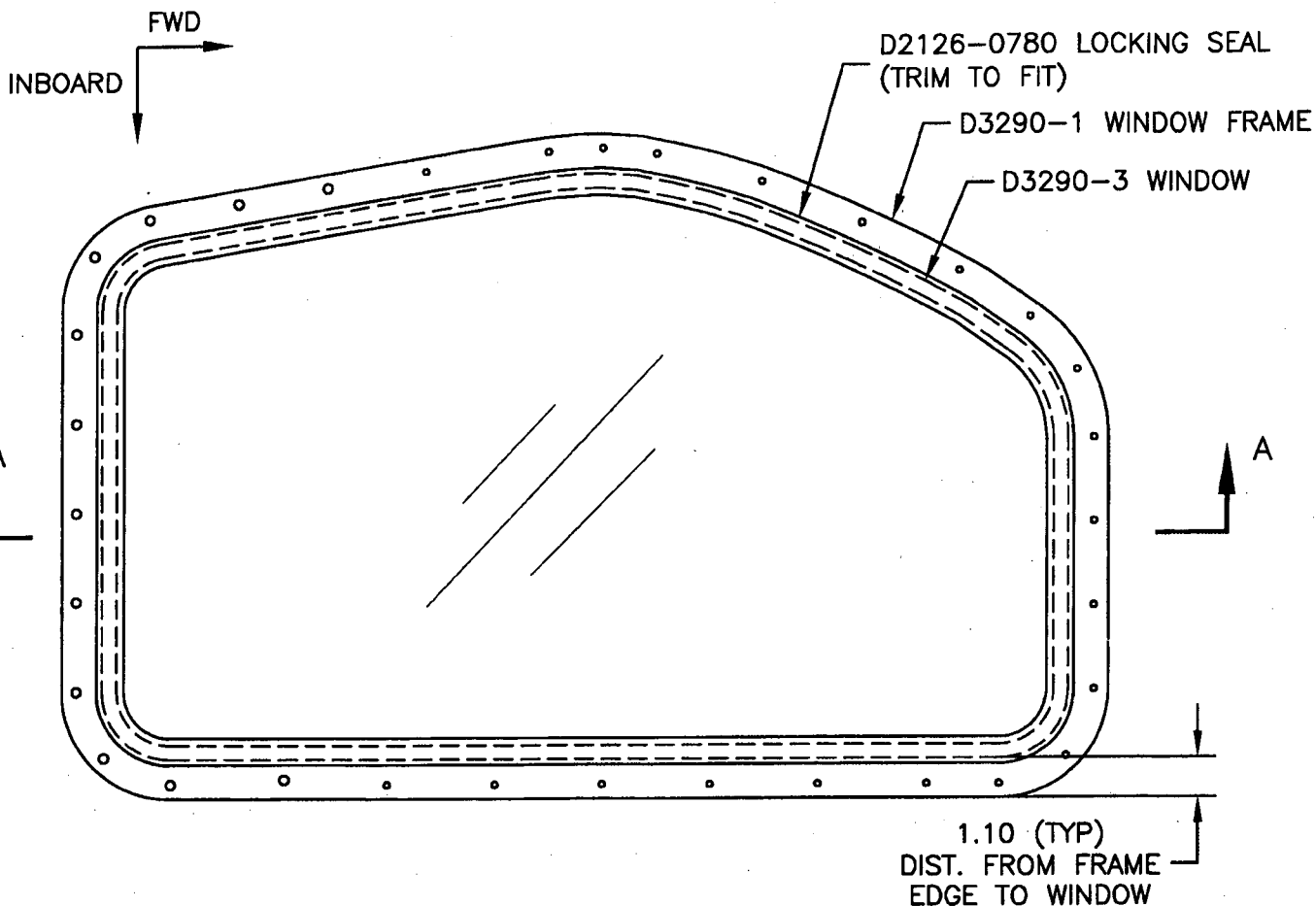
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN RF	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3290	REV. B SHEET 1 OF 3
DATE 06.04.20		TITLE REPLACEMENT WINDOW ASSEMBLY	SCALE 1:5
A	04.06.14	NEW ISSUE	
B	06.04.20	UPDATE MATERIAL PER NCR 029	



ENSURE D3290-3 WINDOW IS INSTALLED
ON CORRECT SIDE OF D3290-1 WINDOW FRAME

D3290-041

NOTES

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

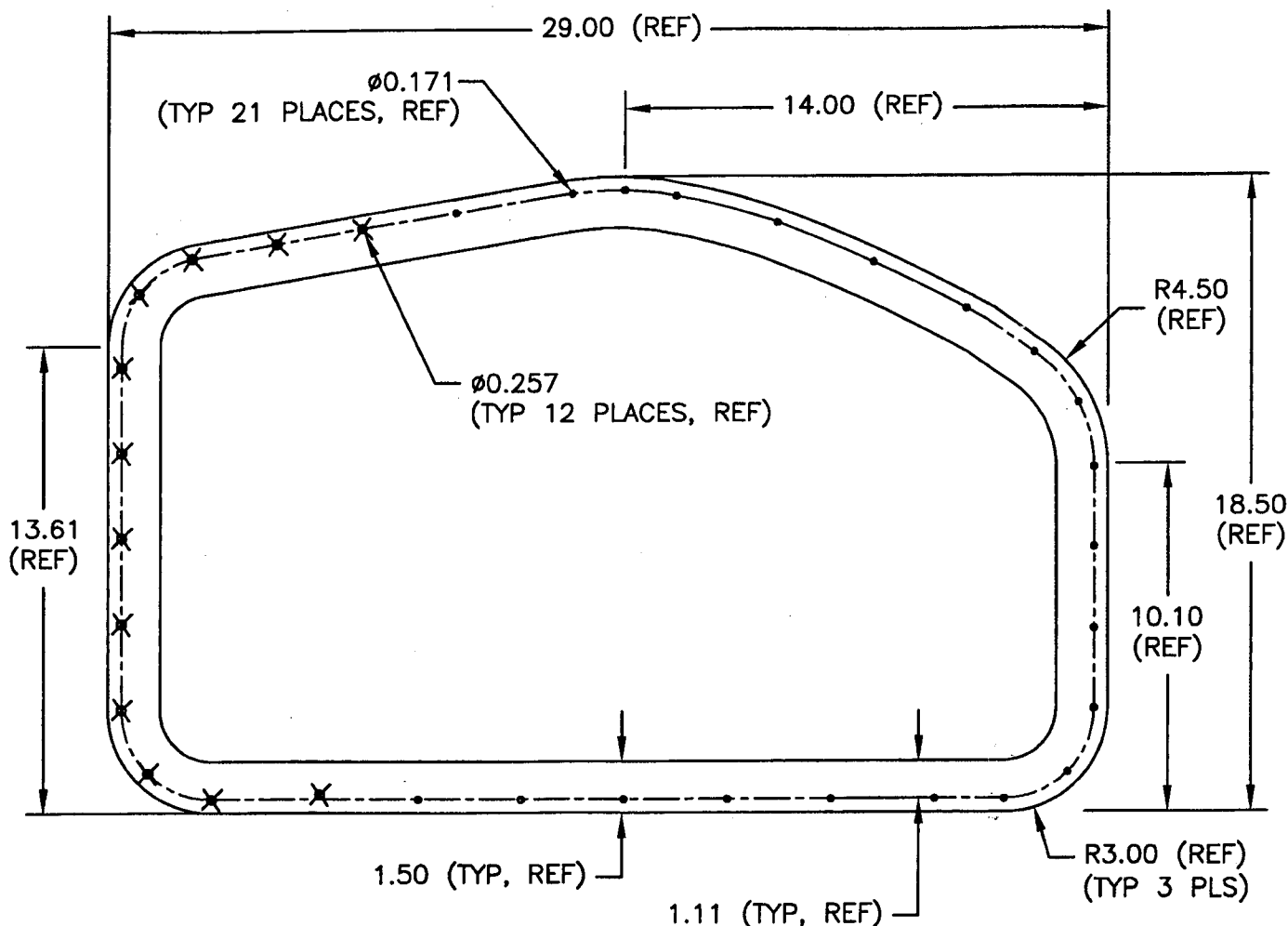
STOP COPY
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06.04.20
AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27566

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3290	REV. B SHEET 2 OF 3
DATE 06.04.20		TITLE REPLACEMENT WINDOW ASSEMBLY	SCALE 1:5



D3290-1 FRAME

D3290-1

- 1) MACHINE PER DRAWING FILE "D3290-A2.DWG"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) SHEET 0.040 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

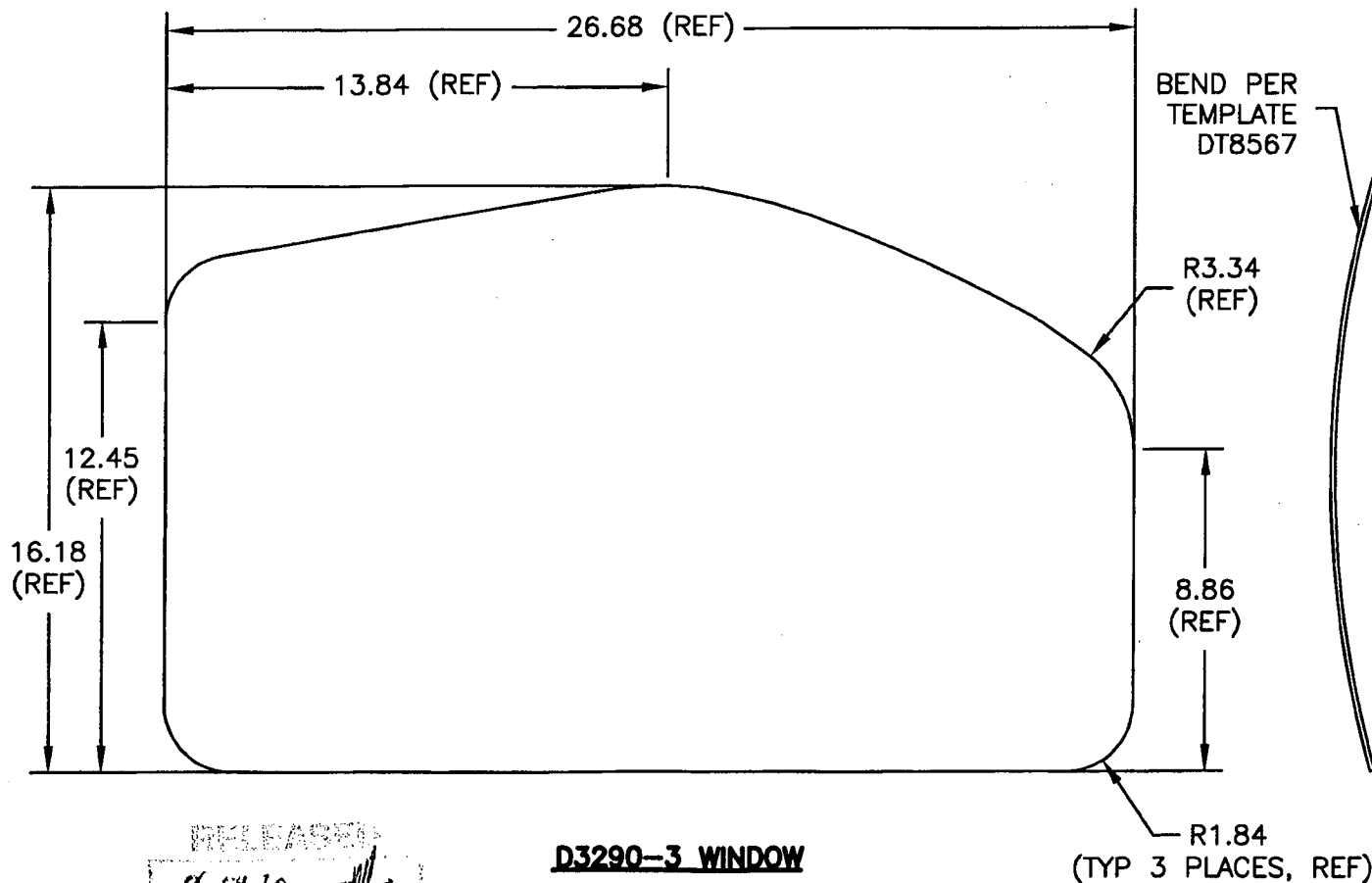
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06.04.20
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DART

DESIGN RF	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3290	REV. B SHEET 3 OF 3
DATE 06.04.20		TITLE REPLACEMENT WINDOW ASSEMBLY	SCALE 1:5



D3290-3
B

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) CHECK PART USING DT3290-3T1

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